

Work Order ID 70997

Monday, June 20, 2011 3:58:26 PM

Page 1

Item ID: D2332-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Lid Prop Assembly 6.69" long

Start Date: 6/20/2011 Start Qty: 6.00

Required Date: 6/23/2011 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-06-20

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2332

Rev C1

100

0.00



Small Fab

Memo

0.00

Small Fab

1- Cut D2332-7 and D2332-5 to length as per dwg D2332.

2- Cut D2332-11 using 1/2" S.S tubing 7.735" long.

3- Deburr.

110

0.00



Brake NC

Memo

0.00

Brake NC

Punch and form D2332-11 to length as per dwg D2332 using DT8012
(need 2 per ass'y)

EPH/06/22 (6)

Handwritten signature/initials

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00



Small Fab

Memo

0.00

Small Fab

1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459
(drill one per ass'y)

2- Ensure no foreign objects inside tube

3- Deburr

Ep/06/22 (6)

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sulacetz

(46)

140

0.00



Large Fab

Memo

0.00

Large Fab

Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y)
*****ensure nothing is inside of tube before welding*****S.S Rod batch: *117384**Cpl 11.07.05*

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Item ID: D2332-041 Accept  Setup Start 
Revision ID:
Item Name: Lid Prop Assembly 6.69" long Stop 
Start Date: 6/20/2011 Start Qty: 6.00  Cust Item ID:
Required Date: 6/23/2011 Req'd Qty: 6.00  Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00			BE 11/07/06 11-07-06	6	0		
160  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00			8-6-07/06	46			
170  Small Fab Small Fab	Memo 1- Tumble 2- Assemble as per dwg D2332	0.00 0.00			B11-7-11 11/07/11			6 6	

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D2332-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Prop Assembly 6.69" long

Start Date: 6/20/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S M 2/11

0.00

Memo



190



Packaging

Packaging

Identify as per dwg & Stock Location: 572

0.00

0.00

Memo

P 4/17/12 (6)

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

11/7/12
MF
11-07-12

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Picklist Print

Monday, June 20, 2011 3:58:32 PM

Page 1

Work Order ID: 70997

Parent Item: D2332-041

Parent Item Name: Lid Prop Assembly 6.69" long




Start Date: 6/20/2011

Required Date: 6/23/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/RF
IPP Rev:C 08-06-02 add comment DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R.250  304 SS Round bar .250		Purchased	No			100	f	10.6747	0.1	0.631579			
				<u>Location</u>				<u>Loc Qty</u>					
				MAT028				10.674736					
				114482				10.674736					
M304TR1.000W.049  304 RD Tube 1.00 x .049W		Purchased	No			100	f	30.5337	0.43	0.631579 2.715789			
				<u>Location</u>				<u>Loc Qty</u>					
				MAT018				30.533684					
				108756				2.4					
				111457				12.66					
				117598				15.473684					
M304TR0.500W.035  304 RD Tube .500 x .035W		Purchased	No			110	f	194.7796	1.25	7.894737			
				<u>Location</u>				<u>Loc Qty</u>					
				MAT017				194.779638					
				115535				2.33					
				116720				1.66068					
				117598				190.788958					

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Page 2

Work Order ID: 70997

Parent Item: D2332-041

Parent Item Name: Lid Prop Assembly 6.69" long

Start Date: 6/20/2011

Required Date: 6/23/2011

Start Qty: 6.00

Required Qty: 6.00

AN4-4A Purchased No

170 Each

96.0000

1

6



Bolt



ES 11/07/11

Location

Loc Qty

Loc Code

FP-B

44

114615

44

ST356

52

114615

52

AN960JD416L NAS1149D0416J Purchased No

170 Each

29.0000

3

18



Washer



ES 11/07/11

M1165B

Location

Loc Qty

Loc Code

FP-B

29

110153

29

MS21042L4 Purchased No

170 Each

4,813.000

1

6



Nut



ES 11/07/11

Location

Loc Qty

Loc Code

ST300

4813

117441

2519

117601

794

117885

1500

6

W/O:		WORK ORDER CHANGES					
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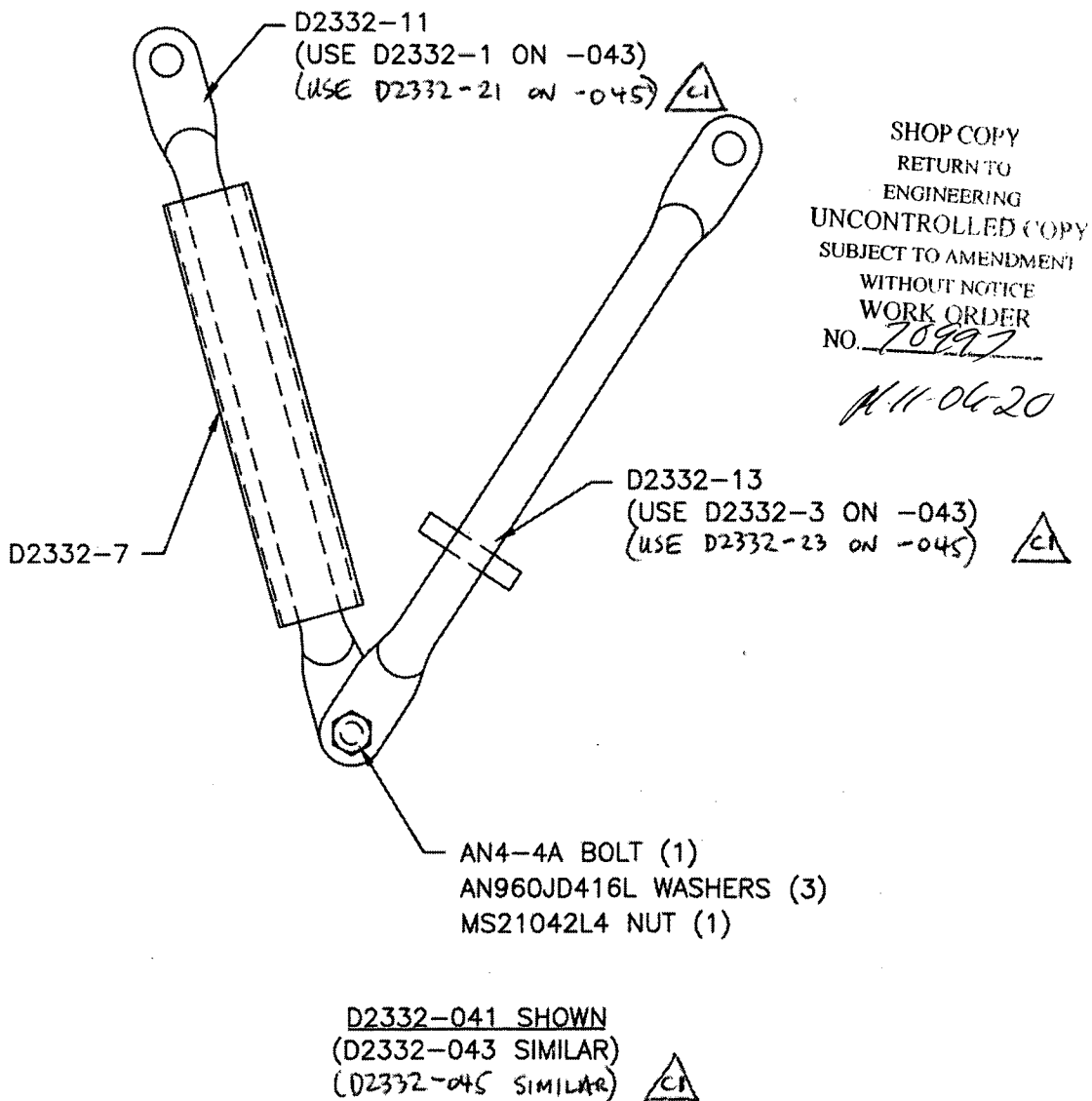
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03		TITLE LOD PROP ASSEMBLY	SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	03.08.06	ADD -045 PROP (7.35" LONG)	

RELEASED
03.07.04 

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DART**DART AEROSPACE LTD**

HAMKESBURY, ONTARIO, CANADA

REV. C

SHEET 2 OF 2

SCALE

1:2

DESIGN

CHECKED

APPROVED

DRAWING NO.

D2332

LID PROP ASSEMBLY

DATE

03.07.03

TITLE

LID PROP ASSEMBLY

DATE

03.07.03

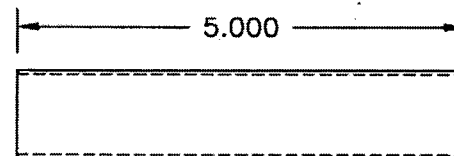
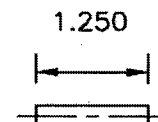
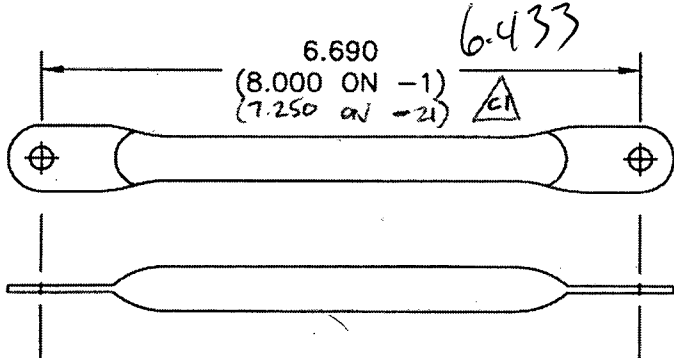
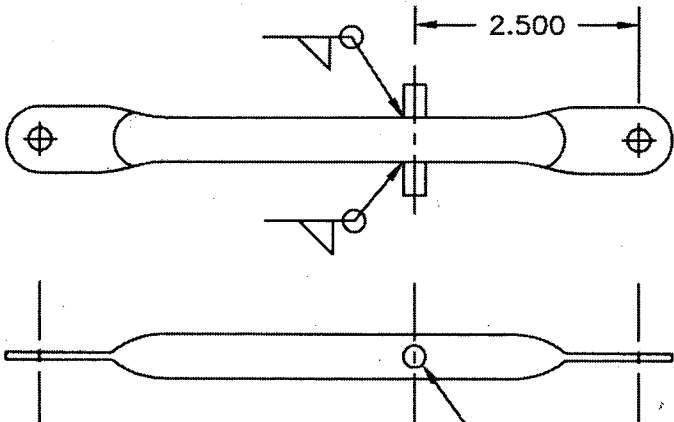
C1

03.08.06

ADD -045 RAD (7.25" LONG)

MAKE -041 PROP 6.69" LONG (STD)

MAKE -043 PROP 8.00" LONG (LON)

**D2332-7 LOCKING COLLAR***w/o 70991***D2332-5 STOP PIN****D2332-11 PROP**
(D2332-1 SIMILAR)**D2332-13**
M/F D2332-11 & D2332-5(D2332-3 SIMILAR - M/F D2332-1 & D2332-5)
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)**NOTES:**

- MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
- TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

RELEASED
03.01.04

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